

Date: Monday, 2/27/2006 4:17:50 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 25968		
Estimate Number	: 10271		
P.O. Number	: N/A	Part Number	: D2561
This Issue	: 2/27/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2561 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25088	Drawing Revision	: B
Written By	: SEE COMMENT BELOW		
Checked & Approved By	: JF 06-02-28		
Comment	Est C	00.05.19	Added inspect level 8 EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0250X06000	6061-T6 Bar .25" x 6.0"
		
		
	Comment: Qty.: 0.3850 f(s)/Unit Total: 15.4014 f(s) Material: 6061-T6, or 5052-H34 6.00" x 0.25" Thick Batch: <u>M17869 = 139.2 inches</u> <u>M17037 = 43.5 inches</u>	
		J.L 06.03.01 21
2.0	BAND SAW	BAND SAW
		
		
	Comment: BAND SAW 1-Cut blanks: 8.70" Note: 1 blank makes 2 parts	
		J.L 06.03.01 42
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
		
	Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per folio D2561 2 Deburr, no sharp edges Sent to C&T	
		J.L 06.03.01 42
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
		J.L 06.03.01 42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LUG

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Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ml 06/03/01

42

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr , no sharp edges

SBS

06/03/08

42

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA*

SBS 06/03/08

42

8.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

100 06/03/09

(42)

Job Completion



u 06w309

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25968
Description: Lug Plate	Part Number:	D2561
Inspection Dwg: D2561	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

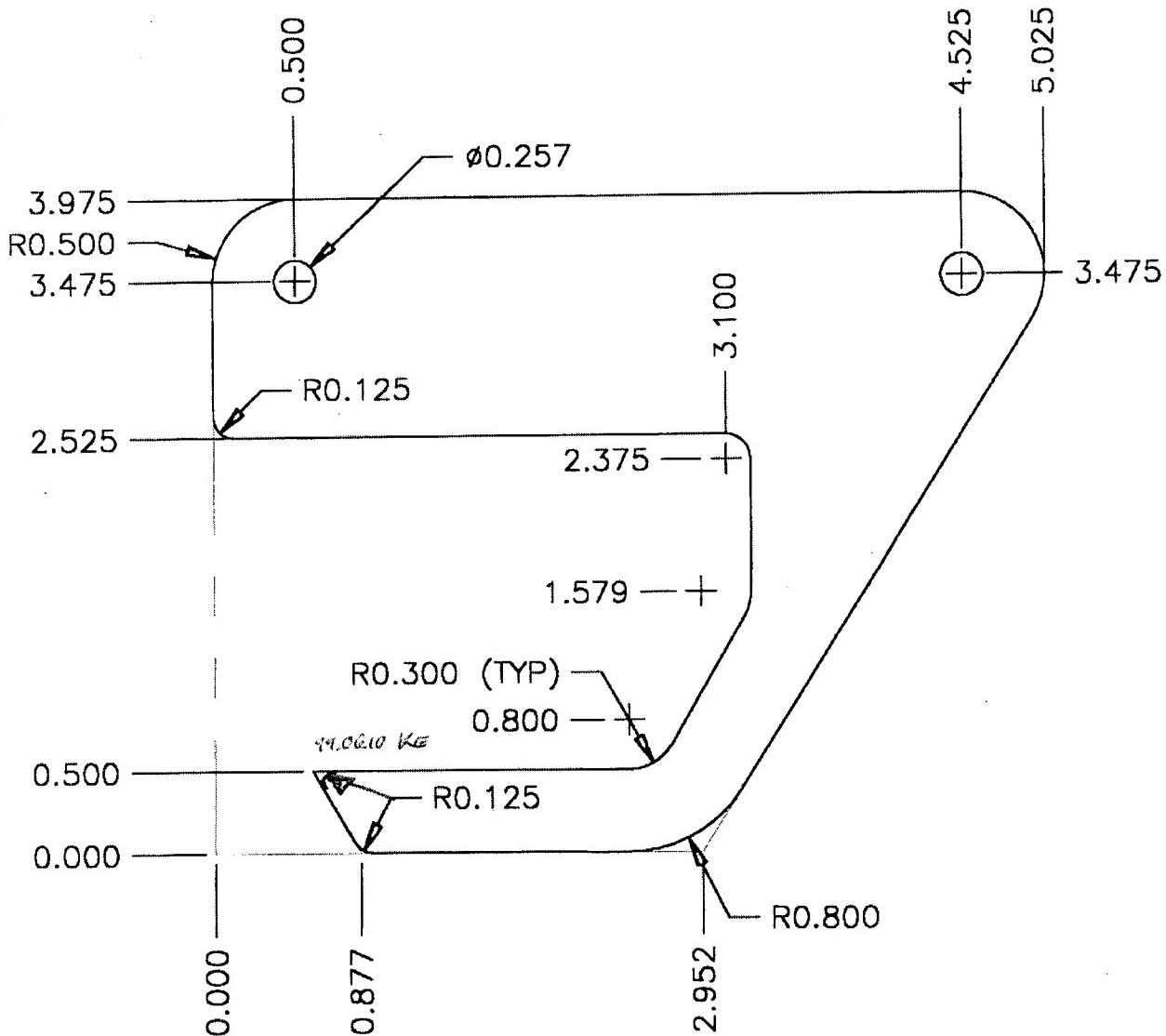
Measured by:	JL	Audited by:	mk	Prototype Approval:	N/A
Date:	06.03.01	Date:	06/03/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>Bu</i>	APPROVED <i>Bu</i>	DRAWING NO. D2561	REV. B SHEET 1 OF 1
DATE 96.04.26	TITLE LUG PLATE		SCALE 1:1

RELEASED
96 05 06



MATERIAL: 6061-T6 0.25 THICK
OR 6063-T6 0.25 THICK
OR 5052-H34 0.25 THICK

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25968